

Date: Friday, 01/08/2008 2:33:39 PM
User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: BACK LEG ASSEMBLY
Job Number	: 40873-1	Part Number	: D3782045
Estimate Number	: 13323	Drawing Number	: D3782 REVA
P.O. Number	:	Project Number	: N/A
This Issue	: 01/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 31/07/2008 Type : SMALL /MED FAB	Due Date	: 08/08/2008
Previous Run	: 40306	Qty:	split 4. 24 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 08.8.01</u>		
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D37721	Back Leg
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(P.D)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)
Back Leg
batch: 840989.

FF 08/08/20

3.0	D37871	Foot
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)
Foot
batch: 40319

MF

4.0	D37641	Back Leg Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)
Back Leg Fitting
batch: 40970

MF

5.0	D3773041	Headrest Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)
Headrest Assembly
batch: 40980

MF 08.08.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3782-045 PAR #: N/A Fault Category: FAB - Su/med NCR: Yes No DQA: 1 Date: 08.08.22
D412-769-0431/44
 Resolution: _____ Disposition: _____ QA: N/C Closed: 2 Date: 20/08/22

NCR: <u>40873</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/20</u>	<u>IS</u>	<u>During assembly of D3772-1 it was found that the top holes are fd by 0.090. R.L. holes were drilled and missed during inspection</u>	<u>pas1ue12</u>	<u>Scrap and Destroy at 411 And replace on Drillent w/o # 40989-3</u>	<u>08/08/20</u> <u>FF 08/08/20</u>	<u>08/08/20</u>	<u>pas1ue12</u>	<u>08/08/20</u>
								<u>08/08/20</u>

NOTE: Date & initial all entries

1. 2. 3. 4. 5.

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 40873

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D37861

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Sleeve

batch: 40318

mf

7.0

AN515A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

batch: m108860

mf

8.0

AN517A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

batch: m108805

mf

9.0

AN45 15A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

EYE BOLT

batch: m107938

mf

10.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

batch: m108071

mf

11.0

AN960JD516

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 120.0000 Each(s)

Washer

batch: m108246

or (NAS1149D0568J)batch:

mf

12.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

batch: m108161

or (NAS1149D0463J)batch:

mf 08/08/2008

Form: rprocess

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BACK LEG ASSEMBLY

Job Number: 40873

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

batch: m108480

mf

14.0

MS21042L5

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 72.0000 Each(s)

Nut

batch: m108471

mf 08-08-18

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

FF 08/08/20 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 x40

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G7A

S 08/08/20 (24)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21 (4)

Job Completion



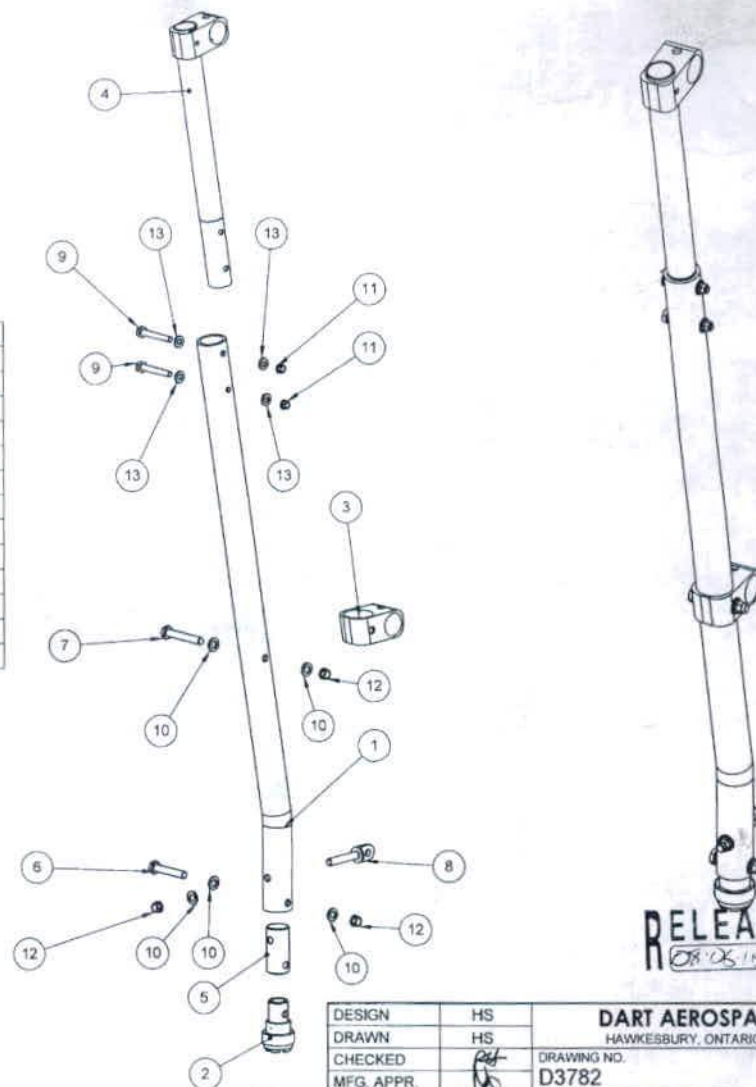
mf 08-08-21

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

D3782-045 BACK LEG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



RELEASED
08-05-16-144

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.		D3782	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

